

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-011706**Date Inspected:** 24-Jan-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Wuzhi Chang, Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girder(OBG)**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Manoj Prabhune was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

OBG # TRIAL ASSEMBLY YARD (7BE-7CE)

This QA inspector performed offset & Root Gap for OBG Segment along with Caltrans QA inspector (Mr. Surendra Prabhu) for below segment. Reports forwarded to team leader for further action

7BE-7CE

This QA Inspector randomly observed the following work in progress:

OBG # TRIAL ASSEMBLY YARD (6CE-PP47)

This QA inspector observed, ZPMC qualified welding personnel identified as 068764 perform Shielded Metal Arc Welding (SMAW), weld joint identified as SEG032D-001 , ZPMC QC identified as Mr. Wang LI Yang. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2212-TC-U4b-FCM-1

This QA inspector observed, ZPMC qualified welding personnel identified as 068596 perform Flux Core Arc

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Welding (FCAW), weld joint identified as OBE7C-008, ZPMC QC identified as Mr. Wang Li Yang. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2231T

Segment# 7BE-7CE (PP-52,PP-53)

This QA inspector observed, ZPMC qualified welding personnel identified as 067949 perform Flux Core Arc Welding (FCAW), weld joint identified as OBE7A-008, ZPMC QC identified as Mr. Shenjian Bo. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-223(2)1T-2

This QA inspector observed, ZPMC qualified welding personnel identified as 220067 perform Flux Core Arc Welding (FCAW), weld joint identified as OBE7A-007, ZPMC QC identified as Mr. Shenjian Bo. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-223(2)1T-2

Segment# 6CE-PP47

This QA inspector observed, Heat Straightening of weld joint identified as SEG033B-005~008 & SEG033C-019~022

ZPM QC is identified as Wang Lai Yang. The variables recorded by QC appeared to comply with the Heat Straightening Report (HSR) was HSR1 (B) -8036.

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang phone: 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Prabhune,Manoj	Quality Assurance Inspector
Reviewed By:	Miller,Mark	QA Reviewer
